



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
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Tel (613) 632-5200

D5134-041
Job Sheet 165628



Part No: D5134-041

Job Qty: 8 ea

Part Name: Damper Support Assembly, LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/30/17

Job Tracking No:

Due Date: 10/31/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV B IPP REV:A NEW ISSUE 14-09-09 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Part/Part Name	Part Note	Serial No	Quantity	Location
D5134-041 Damper Support Assembly, LH	DWG REV B IPP REV:A NEW ISSUE 14-09-09 JLM VERIFIED BY:DD		0.000	
M7075T73B3.000X4.000 7075-T73 Bar 3.0 X 4.0 Grain Direction Along 3"			0.000	
NAS77C6-021 Bushing			0.000	

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	8 Ea	10/28/17	0.00	0.00	Start up container	
100	Bandsaw	8 pcs	10/28/17	0.00	0.47	Bandsaw1	
110	CNC Vertical Machining	8 pcs	10/30/17	1.03	18.60	HAAS 1	
120	QC	8 pcs	10/30/17	0.00	0.00	QC2	
130	QC	8 pcs	10/30/17	0.00	0.00	QC8	
135	HandFinish	8 pcs	10/30/17	0.00	0.53	HandFinish1	
137	QC	8 pcs	10/30/17	0.00	0.00	QC7	
140	SprayPaint	8 pcs	10/30/17	0.00	2.08	Spray Paint	
150	QC	8 pcs	10/30/17	0.00	0.00	QC14	
160	Small Fab	8 pcs	10/31/17	0.00	1.15	Small Fab	
170	QC	8 pcs	10/31/17	0.00	0.00	QC5	
180	Packaging	8 pcs	10/31/17	0.00	0.00	Packaging3	
190	QC21-SA	8 Ea	10/31/17	0.00	0.00	QC21	

Part Op 100 - CUT BLANK TO 5.125" LONG *****CHECK GRAIN DIRECTION*****

Descriptions: 110 - Mill as per Dwg and folio FB342

140 - ***MASK BEARING HOLE AS PER NOTE 2*** PRIME AS PER DWG AND QSI BATCH: 138676 PAINT AS

PER DWG AND QSI BATCH: 138637

160 - install bushings as per dwg

180 - LOCATION LG054

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M7075T73B3.000X4.000	3	0	0	0
160-Small Fab	NAS77C6-021	16	0	0	0

Part Specifications

S000856



PART NO: D5134-041

Revision:

Operation: Start up Operation

Quantity: 8

Change No:

Mfg Date: 10/18/17

Job No: 165628

Specifications could not be found.

Plex 10/2/17 2:41 PM Dart.lajeunesse.marie

Handwritten notes and signatures are visible in the lower right quadrant of the page, including the word "REAL" and some illegible scribbles.

Work Order ID 165628

Monday, August 28, 2017 11:58:40 AM

165628

Page 1

Item ID: D5134-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Damper Support Assembly, LH
 Start Date: 8/16/2017 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 8/28/2017 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: DAS 21 Date: AUG 30 2017 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D5134	B

100 0.00 ***100*** 8 0 DAS 1 9-89 17-10-17
 Bandsaw Memo 0.00
 Jeaspa Bandsaw CUT BLANK TO 5.125" LONG
 *****CHECK GRAIN DIRECTION*****

110 3.90 ***110*** 8x 2 10/20 2017
 HAAS I Memo 4.98
 HAAS CNC vertical machine #1 Mill as per Dwg and folio FB342
 DWG REV: B
 FOLIO REV: AA
 DEBURR

DQA:

Date:

17-10-18



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

DAS
53
9-89

Date:

DEC 14 2018

Work Order update only ☐

Work Order: <u>165628</u> Part No. <u>05134-041</u> NCR No. <u>18-7042</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☒</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>			Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																			
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Date: <u>17/10/18</u>	Step #: <u>110</u>	QTY Effective: <u>2</u>	MRB (QSI042) Approval DAS 12 9-89 <u>17/10/25</u>																																																																			
Description Work Order Deviation <u>1st part</u> - The wrong parameter for the 4 axis was used causing the center drill to drill the wrong spot position <u>2nd part</u> - The reamer open to Ø.5012 - the bushings slides right in.		Disposition <u>Scrap in replace to 138086</u> <u>Scrap in replace to 138252</u>		Completed By DAS 1 9-89 Lead hand / Supervisor Approval 38 9-89 <u>OCT 24 2017</u> QC / QA Coordinator Approval 38 9-89 <u>OCT 24 2017</u>																																																																		
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Monday, August 28, 2017 11:58:40 AM

Page 2

Hand Finishing

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☒</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Date : <u>13-04-13</u>	Step #: <u>160</u>	QTY Effective : <u>3</u>	MRB (QSI042) Approval																																																																	
Description Work Order Deviation		Disposition		PD 13-04-13																																																																
bushing in parts where pressed in cracked and damage the hole.		Scrap destroy qty 3 no replace		Completed By  Lead hand / Supervisor Approval Verification  QC / QA Coordinator Approval PD 13-04-13																																																																
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Work Order ID 165628

Monday, August 28, 2017 11:58:40 AM

165628

Page 3

Item ID: D5134-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Damper Support Assembly, LH
Start Date: 8/16/2017 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 8/28/2017 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
137 *137* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.08				_____	_____	_____	_____
140 *140* SprayPaint Spray Painting	Spray Painting per QSI005 4.2 Memo ***MASK BEARING HOLE AS PER NOTE 2*** PRIME AS PER DWG AND QSI BATCH: _____ PAINT AS PER DWG AND QSI BATCH: _____	0.00 4.96				_____	_____	_____	_____
150 *150* QC Quality Control	QC14- Inspect Spray Paint Memo	0.00 0.08				_____	_____	_____	_____

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Work Order ID 165628

Monday, August 28, 2017 11:58:40 AM

165628

Page 4

Item ID: D5134-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Damper Support Assembly, LH

Start Date: 8/16/2017 Start Qty: 8.00

8

Cust Item ID:

Required Date: 8/28/2017 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00							
160									
Small Fab	Memo	0.72							
Small Fab	install bushings as per dwg								
170	QC5- Inspect part completeness to step on W/O	0.00							
170									
QC	Memo	0.16							
Quality Control									
180	Identify as per dwg & Stock Location: _____	0.00							
180									
Packaging	Memo	0.08							
Packaging	LOCATION : LG054								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
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			Completed By		
			Lead hand / Supervisor Approval Verification		
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OTHER :					

Monday, August 28, 2017 11:58:40 AM

Page 5

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																													
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Picklist Print

Page 1

Monday, August 28, 2017 11:58:44 AM

Work Order ID: 165628

165628

Parent Item: D5134-041

D5134-041

Parent Item Name: Damper Support Assembly, LH

Start Date: 8/16/2017

Required Date: 8/28/2017

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A NEW ISSUE 14-09-09 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T73B3.000X4.00 0		Purchased				100	f	19.0790	0.427	3.59579			
									**			DAS 1 9-89	17-10-17
M7075T73B3 000X4 000													
7075-T73 Bar 3.0 x 4.0 grain direction along 3"													

Location	Loc Qty	Loc Code
----------	---------	----------

MAT	7.079	
-----	-------	--

m138086	7.079	
--------------------	-------	--

MAT006	12	
--------	----	--

m138252	12	
---------	----	--

NAS77C6-021

Purchased

No

160

Each

379.0000

2

16

NAS77C6-021

**

BUSHING

Location	Loc Qty	Loc Code
----------	---------	----------

ST554	379	
-------	-----	--

M134793	129	
---------	-----	--

M134833	250	
---------	-----	--

DQA: _____ Date: _____



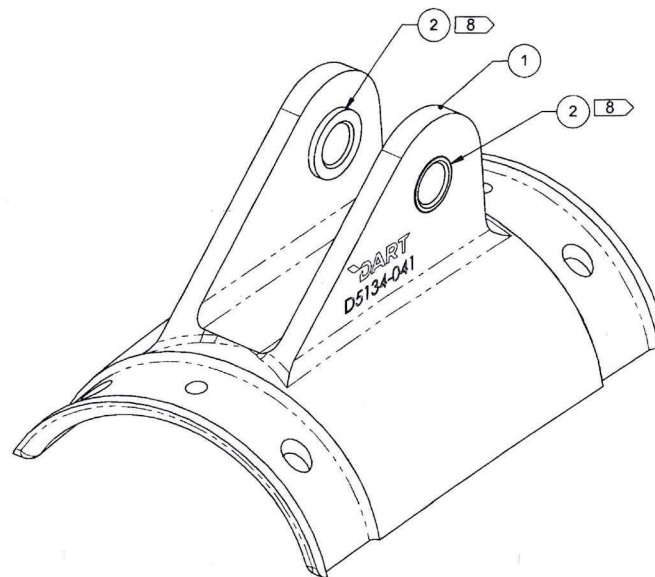
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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ITEM	QTY	P/N	DESCRIPTION
	X	D5134-041	DAMPER BRACKET ASSY, LH
1	1	D5134-1	DAMPER SUPPORT, LH
2	2	NAS77C6-021	BUSHING



D5134-041 DAMPER SUPPORT ASSY, LH

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PRIME AND PAINT WHITE PER DART QSI 005 4.2
MASK OFF INNER SURFACE OF BUSHING PRIOR TO APPLICATION OF PRIME/PAINT
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.42 lbs
- 8) NAS77C6-021 BUSHINGS ARE PRESS FIT INTO D5134-1 DAMPER SUPPORT, IN ORIENTATION SHOWN

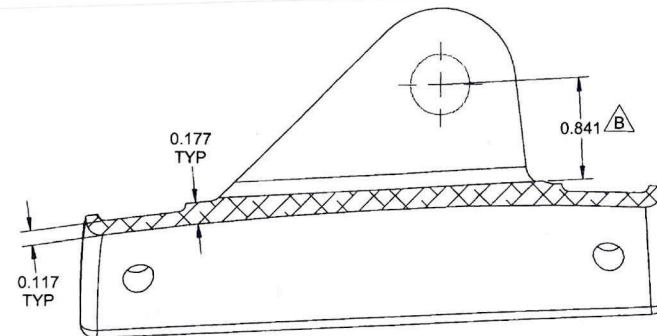
SHOP COPY
REF RNTD
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 165628 MJS
1708-30

RELEASED

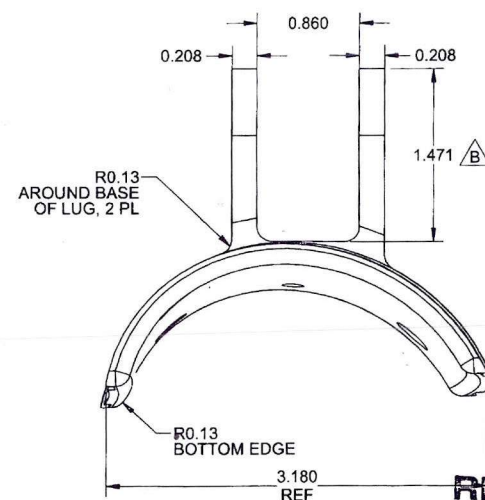
2015 MAY 12
A.R. Ecnis-520

B	7075-T73 MATERIAL WAS 7075-T6, MINOR DIMENSIONAL CHANGES (SHT 3 & 4)	AP	15.04.24
A	NEW ISSUE	AP	14.09.02
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	CP	DRAWING NO.	REV. B
MFG. APPR.	JLM	D5134	SHEET 1 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	DAMPER SUPPORT ASSY	
DATE	15.04.24	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED



SECTION A-A



RELEASED

2015 MAY 12

A.P. ECM5-570

D5134-1 DAMPER SUPPORT, LH

NOTES:

- NOTES:**
- (B)** 1) MATERIAL: ALUMINUM 7075-T73 (T7351 / T73510 / T73511) BAR
PER AMS-QQ-A-200/11 OR AMS-QQ-A-225/9 (AMS 4124) OR
AMS-QQ-A-250/12 (AMS 4078), REF DART SPEC M7075T73B
- 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART LOGO AND P/N "D5134-041" IN AREA SHOWN
USING 0.125 HIGH X 0.010-0.020 DEEP LETTERING PER DART QSI 044 6.3,
IDENTIFY WITH DART B/N PER DART QSI 044 6.1
- 7) WEIGHT: 0.38 lbs
- 8) ALL NON-DIMENSIONED FEATURES DEFINED PER DRAWING FILE "D5134-1-REVB.SLDPR1"
- 9) POSITION TOOLING HOLES AS REQUIRED WHILE MAINTAINING MINIMUM 2D EDGE DISTANCE AND 4D PITCH BETWEEN HOLES

APPROVED	DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D5134 TITLE DAMPER SUPPORT ASSY SCALE NTS
	DRAWN	AP	
	CHECKED	CP	
	MFG. APPR.	JLM	
	APPROVED	HS	
	DE APPR.	DS	
DATE 15.04.24		COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON OR ENTITY	